

**Work Order ID 52870**

October 16, 2009 10:07:21 AM

Page 1



Item ID: D206-642-541

Accept



Setup Start



Revision ID: M

Stop



Item Name: Replacement Skid:ube

Start Date: 16/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *BS*Date: *09-10-16*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile &amp; type labels per PPP D206-642-541

CHG003

*N/A*

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Reference:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274, cut fwd end of tube with saw table setup D3274.

9-10-20

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding => SAD 09-10-21

①

3- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch: M109213/M111999

4- grind fwd cap weld on top surface only

85 09-10-22

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

M

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9-10-22

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00	SAO 09-10-22						
130  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	27 80810124						
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	27 80810126						

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Start Date: 16/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☒ M112391 ☐

Sikaflex expire date: ☐ 10/2/13 ☐

Start: ☐ 9/10/29 ☐ Time: ☐ 2:30 ☐

Finish: ☐ 9/10/29 ☐ Time: ☐ 10:30 AM

(Adhere for 12 hours)

- AWM 9-10-26

1 10/10/29

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

2) 8 Oct 16/30

0.00

Memo

40

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Start Date: 16/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

0.00



Skidtubes

Skidtubes

0.00

Memo

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

DP 9-11-2

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-IT2  
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT895 FWD  
END OF TUBE  
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)  
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

4 9/11/13

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

9/8/10/03

(9)

Quality Control

L = 3.00"  
L' = 4.8"

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Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod  
A/R ☐ Aluminum Rod M112507 #6 09/11/04

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ Salubor

1 11/9/11/4

Ⓢ

7

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Item ID: D206-642-541

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Setup Start



Revision ID: M

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Item Name: Replacement Skidtube

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Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

QC10- Inspect visual per QSI004- ground welds

0.00



276 09/11/09

QC

Memo

0.00

Quality Control

220

Pressure Wash per QSI005 4.3

0.00



276 09/11/09

HandFinish

Memo

0.00

Hand Finishing

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



276 09/11/09

Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:15 AM  
OVEN TEMPERATURE: 320°  
FINISH TIME: 9:45 AM

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Setup Start

Stop

Start Date: 16/10/2009 Start Qty: 1.00

Required Date: 02/11/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:




Reference:

Run Start

Stop

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00	MD 09/11/10			XL			
250  HandFinish Hand Finishing	HandFinishing  Memo 1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/R <input type="checkbox"/> N/A <input type="checkbox"/> LPS-3 <input checked="" type="checkbox"/> N/A 2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/R <input type="checkbox"/> <input checked="" type="checkbox"/> Sikaflex-291 <input type="checkbox"/> <input checked="" type="checkbox"/> Sikaflex expire date: <input type="checkbox"/> 10/12/09	0.00  0.00	MD 09/11/10			XL			
260  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo Inspect Nut Plate & Inserts	0.00  0.00				1			09-11-10



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Item ID: D206-642-541  
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Setup Start



Stop



Start Date: 16/10/2009 Start Qty: 1.00  
Required Date: 02/11/2009 Req'd Qty: 1.00



Cust Item ID:  
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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270



HandFinish  
Hand Finishing

HAND FINISHING RESOURCE #1

0.00

0.00

Memo

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☒ m112391

Sikaflex expire date: ☐ 10/20

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: \_\_\_\_\_

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-291 ☒ m112391

Sikaflex expire date: ☐ 10/20

LPS PROXYON BATCH: m104051

WMD 09/11/10

280



QC  
Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

1 \_\_\_\_\_ J. G. 12

**Work Order ID 52870**

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Stop



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Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



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Reference:

Run Start



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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

290

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

PAP 52878

0.00

Packaging

09/12/2 @

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/03  
MF 09-12-02

# Picklist Print

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Page 1

Work Order ID: 52870

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-1-190RevD1		Manufactured	No			110	Each	65.0000	1.0000			

Extrusion Round 3" 206

*9-10-20*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	65	
47575	65	

D3285-1RevA

Manufactured No



Cap

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	27	
47635	27	

D3282-041RevC

Manufactured No



Float Web (206L/407)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	5	
48389	5	

*B52696*

*1 9/10/29*

*1 BF 09-10-22*

# Picklist Print

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Work Order ID: 52870

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			190	Each	593.0000	12.0000			
												
Cross Bolt Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

83

51529

83

Main Warehouse

ST

510

36013

5

47112

383

48271

122

D3275-1RevA1

Manufactured

No

190

Each

28.0000

12.0000



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

28

47464

1

48117

15

48270

12

852510

12

BE 09/11/09

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Parent Item Name: Replacement Skidtube

Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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CR3212-4-03

Purchased

No

250

Each

310.0000

2.0000

Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

310

111359

96

112314

200

15984

14

D3415-041RevB

Manufactured

No

250

Each

93.0000

1.0000

Nut Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

93

33842

93

CCR264SS3-3

Purchased

No

250

Each

267.0000

2.0000

Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

267

11548

52

111827

115

112314

100

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Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			250	Each	5,373.000	78.0000			

Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5373

110511

5373

270

Each

41.0000

1.0000

D3536-15RevA

Manufactured

No



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

41

47711

3

48159

12

51600

26

~~X-78~~ MD 09/11/10

~~X1~~ MD 09/11/10

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Parent Item Name: Replacement Skidtube


Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-23RevA		Manufactured	No			270	Each	30.0000	1.0000			
												
Gasket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 12

51609 12

Main Warehouse

ST 18

30754 1

47713 17

D3536-35RevA

Manufactured No



Gasket

270 Each 39.0000 1.0000

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 39

48160 13

51628 26

XI mmo 09/11/10

XI mmo 09/11/10

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Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

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Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-39RevA		Manufactured	No			270	Each	28.0000	1.0000			



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

12

51637

12

Main Warehouse

ST

16

44648

1

47714

4

48161

11

270

Each

31.0000

1.0000

D3535-15RevB

Manufactured

No



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

18

51671

18

Main Warehouse

ST

13

30750

4

42233

1

48155

8



# Picklist Print

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Work Order ID: 52870



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3535-35RevB      Manufactured      No

270

Each

36.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

36

48157

10

51608

26

270

Each

26.0000

1.0000

D3535-39RevB

Manufactured      No



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

13

51619

13

Main Warehouse

ST

13

48158

13

XI mmo 09/11/10

XI mmo 09/11/10

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Work Order ID: 52870



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-23RevB		Manufactured	No			270	Each	24.0000	1.0000			
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	13	
51618	13	
Main Warehouse		
ST	11	
48156	11	

X1 mwp 09/10/10

D3537-3RevC

Manufactured No

270

Each

69.0000

1.0000



Wearpad

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	69	
30758	7	
33881	17	
35697	45	

X1 mwp 09/11/10

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Parent Item Name: Replacement Skidtube

Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1RevC		Manufactured	No			270	Each	284.0000	9.0000			

Wearpad

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

2

48288

2

Main Warehouse

FP17

265

51624

103

51678

162

Main Warehouse

ST

17

51918

17

AN960C10L

Purchased

No

270

Each

4,396.000 80.0000

washer

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

4296

112116

993

112612

3303

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# Picklist Print

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Work Order ID: 52870



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube


Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C416  washer		Purchased	No			270	Each	704.0000	1.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

704

100993

704

D3672-1RevB

Manufactured

No

270

Each

2,056.000 2.0000



Phenolic Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1556

39275

19

42329

15

47628

522

52505

1000

Main Warehouse

ST117

500

51674

500

X1 MD 09/11/10

X2 MD 09/11/10

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# Picklist Print

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October 16, 2009 10:07:26 AM

Work Order ID: 52870



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube


Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A  BOLT		Purchased	No			270	Each	1,826.000	80.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1826	
112314	40	
112720	124	
112724	178	
<u>112794</u>	984	
112829	500	

X80 MD 09/11/10

AN4C5A

Purchased

No

270

Each

601.0000

1.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	601	
104936	19	
<u>110552</u>	80	
112243	500	
18918	2	

X1 MD 09/11/10

# Picklist Print

Page 12

October 16, 2009 10:07:26 AM

Work Order ID: 52870

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2646RevC		Manufactured	No			270	Each	53.0000	1.0000			
												
Aft Cap												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	53	
20208	0	
43801	1	
46327	4	
48109	48	

21 MD 09/11/10

D3413-1RevA

Manufactured No



Ring

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	20	
48123	20	
Main Warehouse		
ST473	20	
51586	20	

21 MD 09/11/10

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 5870

**DART**

*PL 09-10-21*

RELEASED

07.02.12 *[initials]*

DEO ATTACHED

DESIGN <b>CP</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. <b>D3274</b>	REV. D SHEET 1 OF 4
DATE <b>06.12.19</b>		TITLE <b>SKIDTUBE ASSEMBLY</b>	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

**GENERAL NOTES:**

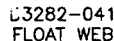
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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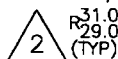
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RELEASED

4



D3274-041 BEND/DRILLING DETAIL

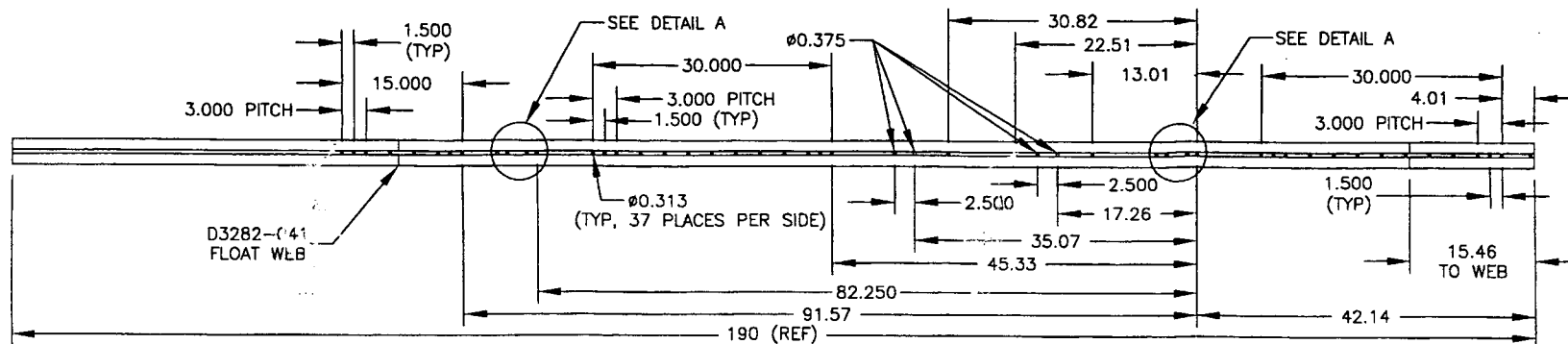


W/O 52870

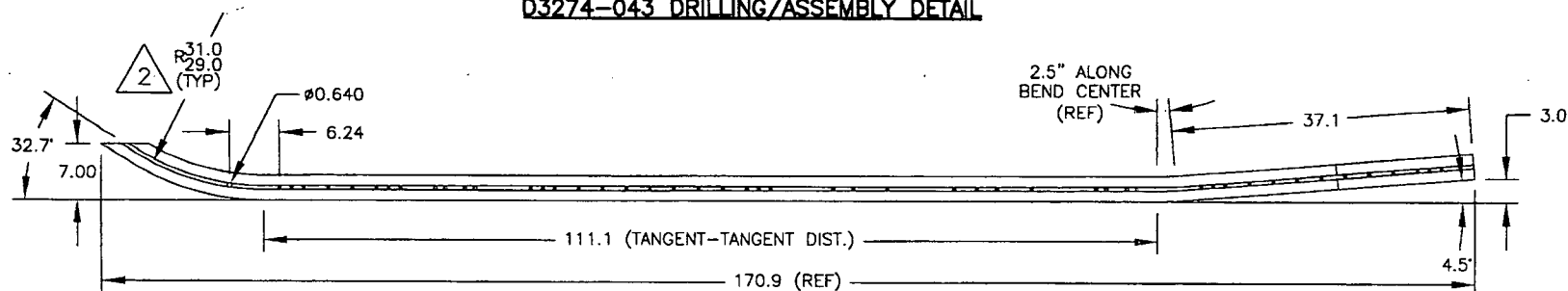
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	CHECKED JH	APPROVED JH	DRAWING NO. D3274	REV. D SHEET 2 OF 4
	DATE 06.12.19	TITLE SKIDTUBE ASSEMBLY		SCALE 1:15



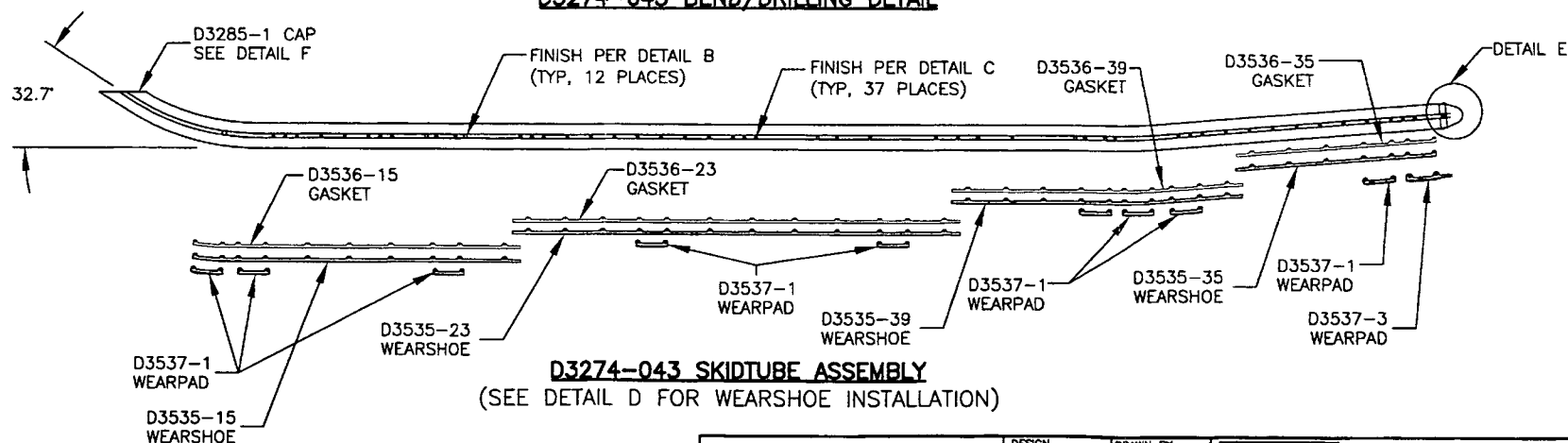
DEO ATTACHED



**D3274-043 DRILLING/ASSEMBLY DETAIL**



**D3274-043 BEND/DRILLING DETAIL**



**D3274-043 SKIDTUBE ASSEMBLY**

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07-02-12

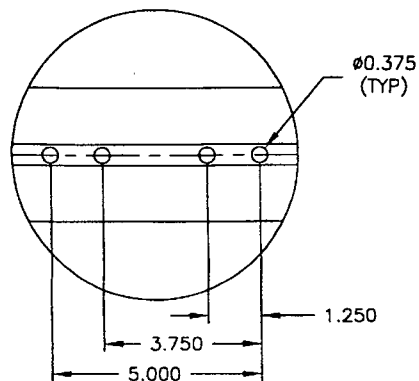
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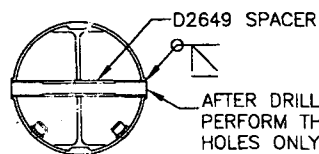
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CHECKED	#	APPROVED	#	PORT HADLOCK, WA	
DATE	06.12.19	DRAWING NO.	D3274	REV. D	SHEET 3 OF 4
		TITLE	SKIDTUBE ASSEMBLY	SCALE	1:15

# **DETAIL A: DRILL DETAIL**

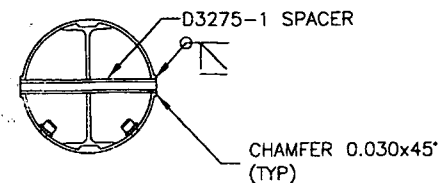


# **DETAIL B** FOR 0.375 HOLES ONLY

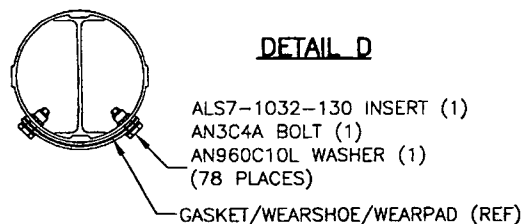


- AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR 0.375  
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE TO 0.313x0.75 DEEP

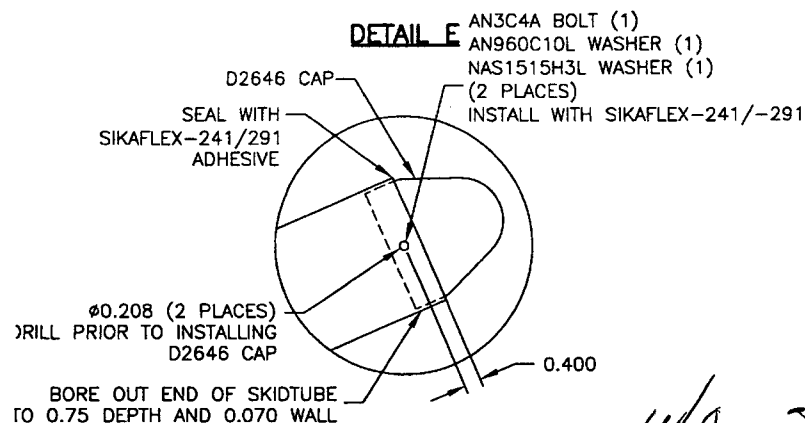
# **DETAIL C** FOR 0.313 HOLES ONLY



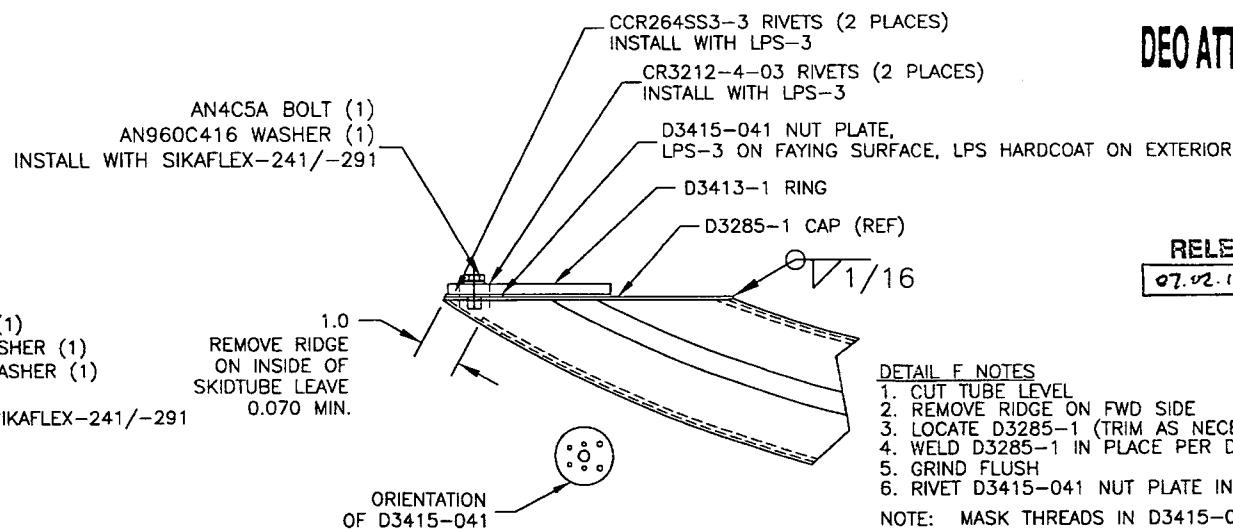
# **DETAIL D**



# **DETAIL E**



# **DETAIL F: END FINISHING DETAIL**



# **DETAIL F NOTES**

1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D3285-1 (TRIM AS NECESSARY)
  4. WELD D3285-1 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

**DEO ATTACHED**

**RELEASED**

07.02.12

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DESIGN	CP	DRAWN BY	PH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	H	APPROVED	H	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 4 OF 4 SCALE 1:3

u/o 52870

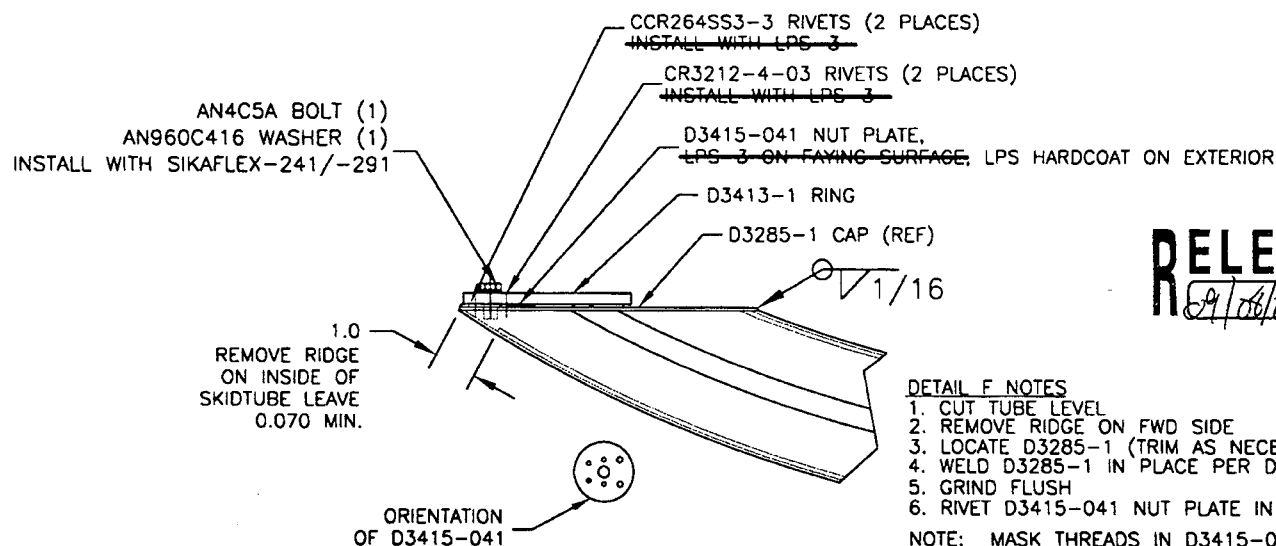
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>M</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

### DETAIL F: END FINISHING DETAIL



#### DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

*W/O 52870*

NO. 214

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 52855  
Part number: D206-642-251  
Description: 206 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat. Dunn Date of Test Coupon 09.10.29  
Welder Barclay Elliott Date of Test Coupon 09.10.29

The above named individual is qualified in accordance with AWS D17.1.2001 to weld